

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008248**Date Inspected:** 13-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wei Shong Shi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY#11

**Magnetic Particle Inspection**

This Q.A Inspector performed Magnetic particle Testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the Fit Lugs on skin B&C, Gusset Plate on skin B&C and weld joint between Diaphragms to skin plate B&C from top double Diaphragm 65m to Diaphragm 80.75m of North Tower Lift 2. Welds designations are as follows.

WSD1-TL6F/L-18~29, 161, 162, 35~46, 48, 49, 107~114, 120~129

WSD1-TL6G/L-11~18, 22~31, 67~74, 80~89

WSD1-TL6H/L-22~33, 206, 207, 39~52, 113~126, 132~147

WSD1-TL6J/L-11~16, 52~54, 22~28

WSD1-SA388C/D-17~19

This QA Inspector randomly observed the following work in progress

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## WELDING INSPECTION REPORT

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BAY#10

FCAW welding process of weld joint 44A located on PCMK SSD1-FDSA4-1C/C. Welder is identified as 053116 ZPMC QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U3-F

SAW welding process of weld joint 24B located on PCMK SSD1-FDSA4-1A/C. Welder is identified as 052917 ZPMC QC is identified as Lu Wei Chao. The welding variables recorded by QC appeared to comply with the WPS-B-T-4221-B-U3C-S-3

SAW welding process of weld joint 16 located on PCMK NSD1-FDSA4-3A/C. Welder is identified as 040460 ZPMC QC is identified as Lu Wei Chao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2321-B-P3-S-2.

SAW welding process of weld joint 68A located on PCMK NSD1-FCSA4-1A/C. Welder is identified as 209051 ZPMC QC is identified as Lu Wei Chao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

SMAW welding process of weld joint 1B located on PCMK ND1-SA250-23M-1. Welder is identified as 040269 ZPMC QC is identified as Yang Ming Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5B-1.

FCAW welding process of weld joint 121 located on PCMK SSD1-FASA4-1E/E. Welder is identified as 203977 ZPMC QC is identified as Wei Shong Shi. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 122 located on PCMK SSD1-FASA4-1E/E. Welder is identified as 201825 ZPMC QC is identified as Wei Shong Shi. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

SAW welding process of weld joint 5B located on PCMK NSD1-FESA4-3A/F Welder is identified as 201750 ZPMC QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

SAW welding process of weld joint 63A located on PCMK NSD1-FCSA4-1A/C. Welder is identified as 220081 ZPMC QC is identified as Lu Wei Chao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

BAY#11

SAW welding process of weld joint 4A located on PCMK WSD1-FASA4-2A/E. Welder is identified as 041716 ZPMC QC is identified as Peng Bmo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

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## WELDING INSPECTION REPORT

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Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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